

# Work Order ID 82784

**\*82784\***

Page 1

April-10-12 7:17:22 AM

Item ID: D3701-1

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Floor Doubler

Stop

**\*NS2\***

Start Date: 4/10/12

Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 4/10/12

Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3701

Rev A

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3701 Dwg Rev: A Prog Rev: A 2-  
Deburr if necessary

6061 0.080

110

0.00

**\*110\***

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

120

0.00

**\*120\***

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sizeluo

mlw/Jan-  
12-4-10

mlw/Jan-  
12-4-10

**Work Order ID 82784****\*82784\***

Page 2

April-10-12 7:17:22 AM

Item ID: D3701-1

Accept

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Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Floor Doubler

Start Date: 4/10/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 4/10/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

**\*130\***

Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

1- Deburr if necessary2- form as per dwg D3701

*B**74**6**SB 12/04/11*

140

**\*140\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*8/2/12**84*

150

**\*150\***

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

*H BLD-11-12.*

# Work Order ID 82784

**\*82784\***

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April-10-12 7:17:22 AM

Item ID: D3701-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Floor Doubler

Stop **\*NS2\***

Start Date: 4/10/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 4/10/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

4 4 11/10/12

170

Identify as per dwg & Stock Location: 157

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

12/4/12

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/4/12

12-04-12

# Picklist Print

April-10-12 7:17:22 AM

Page 1

Work Order ID: 82784  
Parent Item: D3701-1  
Parent Item Name: Floor Doubler

Start Date: 4/10/12  
Start Qty: 4.00  
Required Date: 4/10/12  
Required Qty: 4.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No				sf	580.3200		4.44			
6061-T6 .080 Sheet													

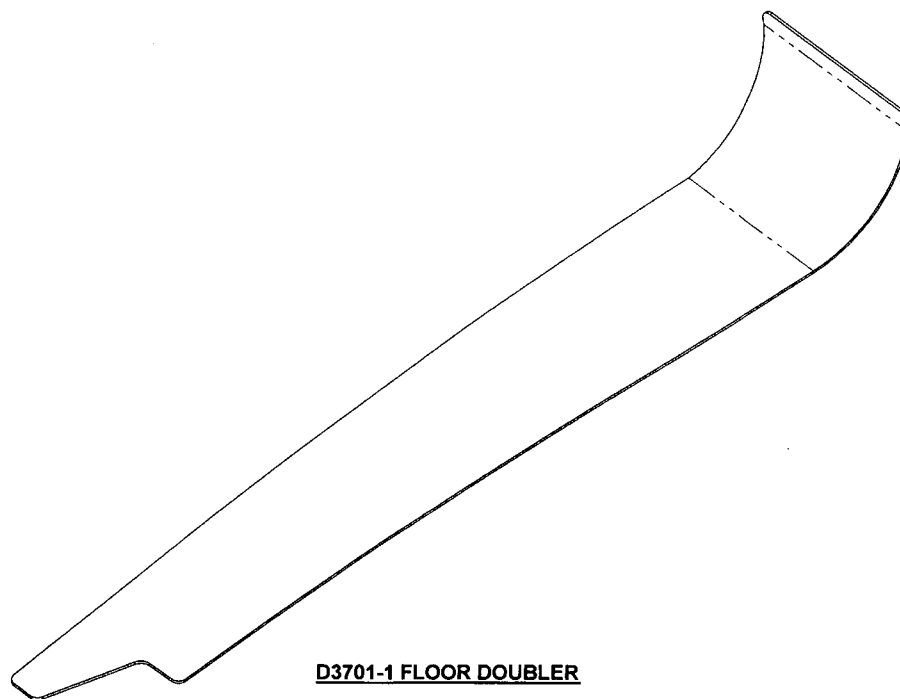
Location	Loc Qty	Loc Code
MAT021	580.32	
117285	2.15	
119766	39.77	
120096	335	
120349	11.4	
121193	192	

4

121096

Wm/Jm-  
12-4-10



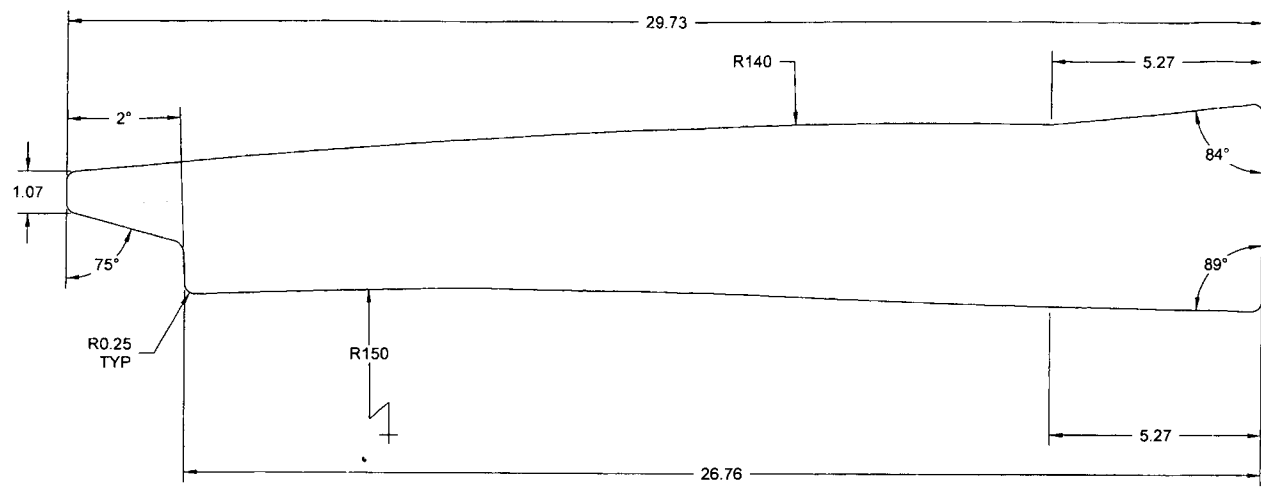


**D3701-1 FLOOR DOUBLER**

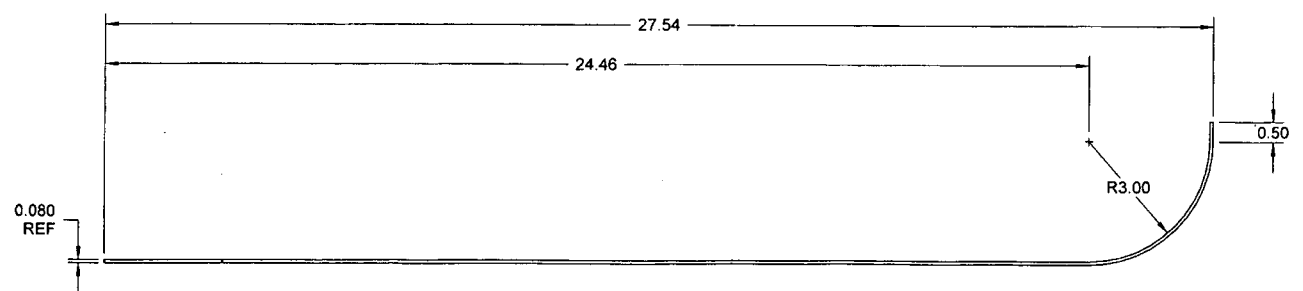
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.080)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3701-1" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.33 lbs
  - 8) MANUFACTURE PART FROM "D3701-1F.DXF" FILE

**RELEASED**  
08/04/08

A	NEW ISSUE	DESCRIPTION	MB	08.04.30
REV.			BY	DATE
DESIGN			<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3701	SHEET 1 OF 2
APPROVED			TITLE	SCALE
DE APPR.			FLOOR DOUBLER	NTS
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**D3701-1F FLAT PATTERN**



**D3701-1 FLOOR DOUBLER  
(MAKE FROM D3701-1F)**

**RELEASED**  
07/04/09

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3701	SHEET 2 OF 2
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